



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60881**

Monday, July 26, 2010 12:29:59 PM



Page 2

Item ID: D2065

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 7/26/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo START TIME: 10:15AM OVEN TEMPERATURE: 320°F FINISH TIME: 10:45AM	0.00  0.00	⇒ JU 10/08/10			6	0		
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	m/l 10 08 17 (6)						
140  Packaging Packaging	Identify as per dwg & Stock Location: ST229  Memo	0.00  0.00	(X6) JB 10/08/18						

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Monday, July 26, 2010 12:29:59 PM

Page 3

Item ID: D2065

Accept

Revision ID:

Item Name: Arm

Start Date: 7/26/2010 Start Qty: 6.00

Required Date: 8/3/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/19 *[Signature]**mf*  
10-8-19

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**NOTE:** Date & initial all entries

# Picklist Print

July 26, 2010 1:34:28 PM

Page 1

Work Order ID: 60881

Parent Item: D2065

Parent Item Name: Arm



Start Date: 7/26/10

Required Date: 8/03/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: E02.04.15 Added Dwg Rev.B1 NG  
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No				f	259.0119	1.7	10.2			

304 RD Tube .500 x .049W

Location

Loc Qty

Loc Code

MAT

243.1789478

114676 ✓

43.1789478

115010

200

MAT017

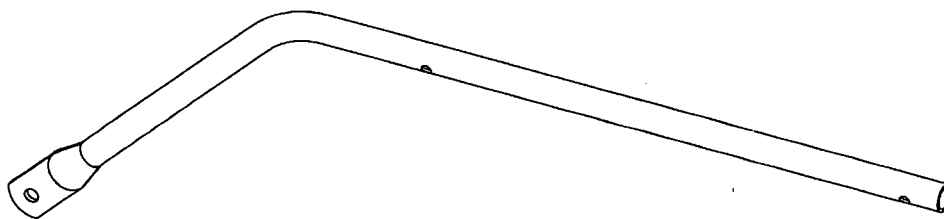
15.833

111814

15.833

10.2

m-h  
10/08/11



**D2065 ARM**

SHOW COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 60881  
*PH 10.726*

**RELEASED**  
*08.07.25.14*

C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A6-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE			PH	08.06.13
B	RE-DESIGN			BW	96.02.06
A	NEW ISSUE			BW	92.03.12
REV.		DESCRIPTION		BY	DATE
DESIGN		BW		<div>DART AEROSPACE LTD</div> <div>HAWKESBURY, ONTARIO, CANADA</div> <div>DRAWING NO. D2065</div> <div>REV. C</div> <div>SHEET 1 OF 2</div> <div>TITLE ARM</div> <div>SCALE NTS</div> <div>COPYRIGHT © 1992 BY DART AEROSPACE LTD</div> <div>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</div>	
DRAWN		PH			
CHECKED		PH			
MFG. APPR.		PH			
APPROVED		PH			
DE APPR.		PH			
DATE		08.06.13			



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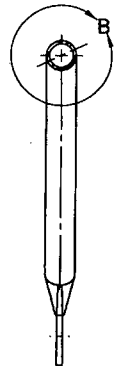
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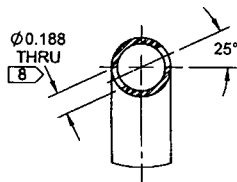
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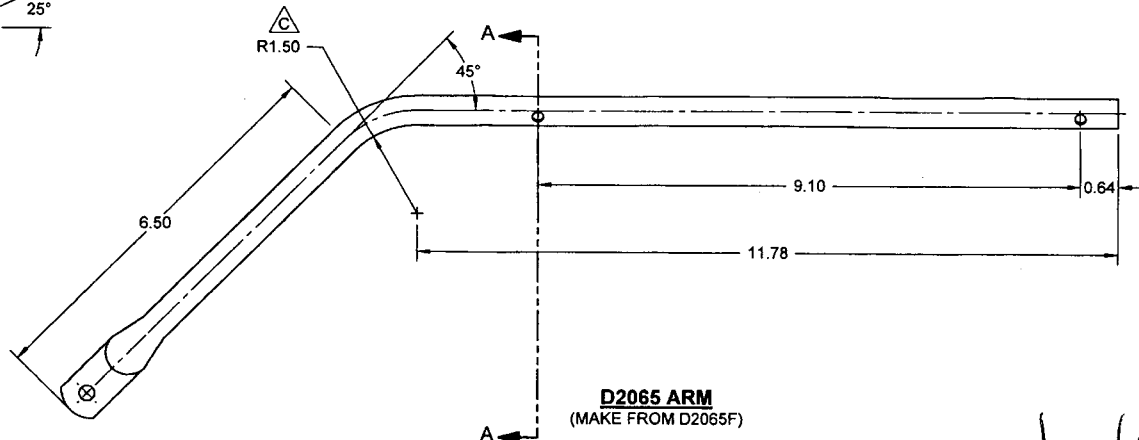
8 7 6 5 4 3 2 1



**SECTION A-A**

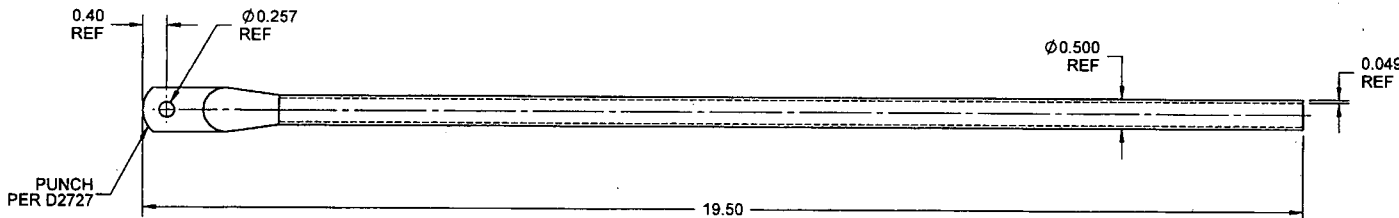


**DETAIL B**  
SCALE 3X  
2 PL



**D2065 ARM**  
(MAKE FROM D2065F)

*w/c 60581*





**D2065F ARM CUT LENGTH DETAIL**



**RELEASED**  
08.07.2013

**NOTES:**

- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\phi 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs
- 8) DRILL  $\phi 0.188$  AFTER BENDING

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	DS	<b>D2065</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>ARM</b>	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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